

AMENDMENTS TO THE CLAIMS

1. (Currently amended) A metal framing member comprising: a formed metal sheet including a plurality of expanded web slots in a region of the formed sheet metal, wherein the region includes a plurality of reinforcements proximate to the web slots.
2. (Original) The member of claim 1, wherein the expanded web slots include voids and metal web elements in the region of the framing member.
3. (Original) The member of claim 1, wherein the formed metal sheet includes a web region and a first flange extending from the web region.
4. (Original) The member of claim 3, wherein the formed metal sheet further includes a second flange extending from the web region in a direction substantially parallel to the first flange.
5. (Original) The member of claim 3, wherein the web region includes the expanded web slots.
6. (Original) The member of claim 3, wherein the first flange includes the expanded web slots.
7. (Original) The member of claim 3, wherein each of the web region and the first flange includes the expanded web slots.
8. (Original) The member of claim 5, wherein each of the web region, the first flange and the second flange includes the expanded web slots.
9. (Original) The member of claim 4, wherein the formed metal sheet further includes a closing region extending the first flange to the second flange to form a substantially tubular structure.

10. (Original) The member of claim 9, wherein each of the web region, the first flange, the second flange and the closing region includes the expanded web slots.
11. (Original) The member of claim 1, wherein each web slot extends along a portion of a length of the member.
12. (Original) The member of claim 1, wherein the plurality of web slots is arranged in offset columns substantially parallel to a length of the member.
13. (Original) The member of claim 1, wherein the plurality of web slots form three or more columns of slots along the length of the member.
14. (Original) The member of claim 13, wherein the plurality of web slots form five or more columns of slots along the length of the member.
15. (Currently amended) The member of claim 2, further comprising additional reinforcements in the web elements.
16. (Currently amended) The member of claim 152, ~~wherein the reinforcements include flanges or darts wherein the reinforcements include a dart or dimple.~~
17. (Currently amended) A preexpanded metal framing member comprising: a formed metal sheet having a length and including a web region and two flanges, each flange extending from the web region, and ~~a plurality of from two to five columns of~~ web slots extending along a portion of the length in the web region or at least one of the flanges.
18. (Original) The member of claim 17, wherein the flanges extend from the web region in a direction substantially parallel relationship.
19. (Original) The member of claim 17, wherein the web region includes the web slots.
20. (Original) The member of claim 17, wherein each flange includes the web slots.

21. (Original) The member of claim 17, wherein each of the web region and the flanges includes the web slots.
22. (Original) The member of claim 17, wherein the formed metal sheet further includes a closing region extending between the flanges to form a substantially tubular structure.
23. (Original) The member of claim 22, wherein each of the web region, the first flange, the second flange and the closing region includes the expanded web slots.
24. (Original) The member of claim 17, wherein the plurality of web slots is arranged in offset columns substantially parallel to a length of the member.
25. (Currently amended) The member of claim 17, wherein the plurality of web slots form ~~three or more~~ exactly two columns of slots along the length of the member.
26. (Currently amended) The member of claim 17, wherein the plurality of web slots form ~~five or more~~ exactly three columns of slots along the length of the member.
27. (Currently amended) A method of manufacturing a framing member comprising: providing a formed metal sheet having a length and a web region; and placing a plurality of slots along a portion of the length in the web region; and placing reinforcements proximate to the slots.
28. (Original) The method of claim 27, wherein providing the formed metal sheet includes roll forming a metal sheet.
29. (Original) The method of claim 27, wherein placing the plurality of slots includes piercing slots into the region.
30. (Original) The method of claim 27, wherein placing the plurality of slots includes stamping the slots into the region.

31. (Original) The method of claim 27, further comprising expanding the slots of the web region to form expanded slots having a web element and a web void.
32. (Original) The method of claim 31, wherein expanding the slots includes passing the formed metal sheet over a tapered block.
33. (Original) The method of claim 31, wherein expanding the slots includes mechanically moving sides of the region apart.
34. (Currently amended) The method of claim 31, ~~further comprising reinforcing the expanded formed metal sheet~~ wherein the reinforcements are placed proximate to the slots before expanding the slots.
35. (Currently amended) The method of claim 27, wherein ~~reinforcing includes placing a or dart in the web element~~ the reinforcements include a dart or dimple.
36. (Original) The method of claim 27, wherein the formed metal sheet includes a first flange extending from the web region and a second flange extending from the web region in a direction substantially parallel to the first flange.
37. (Original) The method of claim 27, further comprising placing a plurality of slots along a portion of the length in each of the first flange and the second flange.
38. (Original) The method of claim 37, further comprising expanding the slots of the first flange and the second flange.
39. (Original) The method of claim 36, wherein the formed metal sheet further includes a closing region extending the first flange to the second flange to form a substantially tubular structure.
40. (Original) The method of claim 27, wherein placing the plurality of slots includes arranging the slots in offset columns substantially parallel to a length of the member.

41. (Original) The method of claim 31, further comprising heat treating the member after expanding the slots.
42. (Currently amended) A method of building a structure comprising: placing an expanded framing member in a portion of the structure, the expanded framing structure including a plurality of expanded web slots forming a plurality of voids in a region of the framing member, wherein the region includes a plurality of reinforcements proximate to the web slots.
43. (Original) The method of claim 42, further comprising installing wiring, plumbing or a heating duct through at least one void of the member.
44. (New) The member of claim 2, wherein the reinforcements include a strengthening flange.
45. (New) The member of claim 17, wherein the plurality of web slots form five columns of slots along the length of the member.
46. (New) The member of claim 17, wherein the web region includes a plurality of reinforcements proximate to the web slots.
47. (New) The member of claim 46, wherein the reinforcements include a dart or dimple.
48. (New) The member of claim 46, wherein the reinforcements include a strengthening flange.
49. (New) The method of claim 31, wherein the reinforcements are placed proximate to the slots after expanding the slots.
50. (New) The method of claim 27, wherein the reinforcements include a strengthening flange.

51. (New) The method of claim 42, wherein the reinforcements include a strengthening flange.
52. (New) The method of claim 42, wherein the reinforcements include a dart or dimple.
53. (New) A method of manufacturing a framing member comprising: providing a formed metal sheet having a length and a web region; placing a plurality of slots along a portion of the length in the web region; expanding the slots of the web region to form expanded slots having a web element and a web void; and heat treating the member after expanding the slots.
54. (New) A metal framing member comprising: a formed metal sheet including a plurality of expanded web slots in a region of the formed sheet metal, wherein the expanded web slots are heat treated.